

Work Order ID 83883

83883

Page 1

April-26-12 2:37:49 PM

Item ID: D3940-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector (407)

Start Date: 26/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/04/27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3940-1	REV A
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100		0.00
-----	--	------

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

JB
12/04/27

105		0.00
-----	--	------

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240

Time IN: 4:45

Time OUT: 7:00

JB
12/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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 Item Name: Floor Protector (407)
 Start Date: 26/04/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 10/05/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110									
Thermoform	Memo	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA042 using tool DT9502 Dwg Rev: <u>A</u> Folio Rev: <u>A</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

2 12/04/27

2 12/04/27

x2 12/04/27

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

2

B 12/05/01

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

2

B 12/05/01

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/12/01

17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 83883***83883***

Page 4

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

2

12/5/12

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

MLJ 12/05/02

Quality Control

MLJ 12/05/02

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April-26-12 2:37:52 PM

Page 1

Work Order ID: 83883

83883

Parent Item: D3940-1

D3940-1

Parent Item Name: Floor Protector (407)

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 09/02/06 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,383.746	9.03	18.06			

MI FXS 118-90318-08

**

Lexan Sheet

Location

Loc Qty

Loc Code

therm

1383.746941

1383.74694

113127

18.06 sf ft

DL
12/04/27

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	83883
Description: Floor Protector		Part Number:	D3940-1
Inspection Dwg: D3940	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 12/04/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
45.8	REF	45.9	✓		TH-05	
20.8	REF	20.8	✓		TH-05	
0.50	Min	.569	✓		TH-01	
0.62	Min	.640	✓		TH-01	
0.38	Min	.489	✓		TH-01	
0.080	Min	.089	✓		TH-01	
0.050	Min	.072	✓		TH DT	

Measured by: JB

Date: 12/05/07

Audited by: Oh

Date: 12/05/01

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.09.17	New Issue	KJ	<u>JA</u>

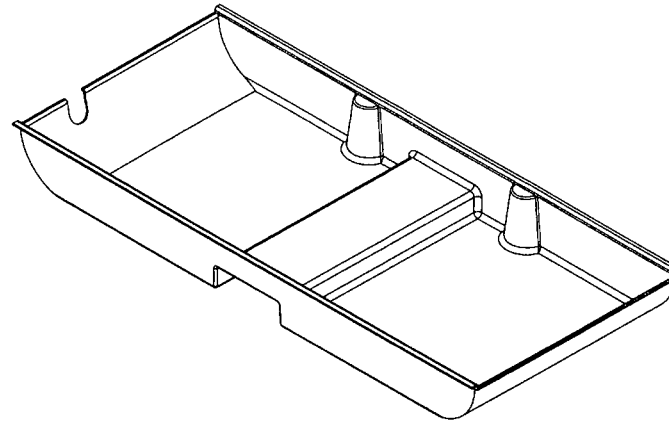
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D3940-1 FLOOR PROTECTOR (407)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 83883 M25

12/04/27

RELEASED
 08/05/08

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3940-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9502 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.01		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3940** REV. A
 SHEET 1 OF 2
 TITLE **FLOOR PROTECTOR (407)** SCALE NTS

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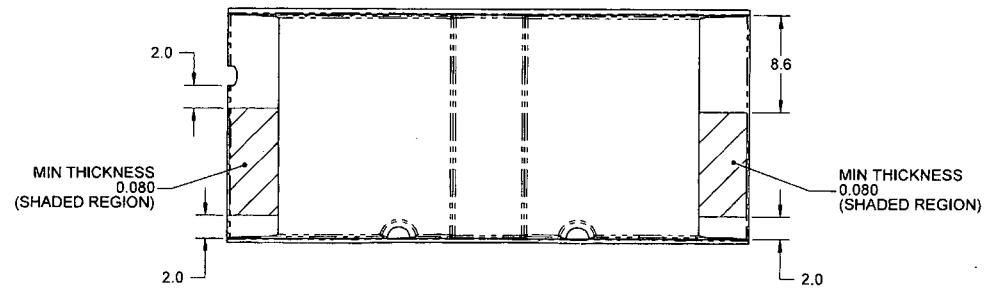
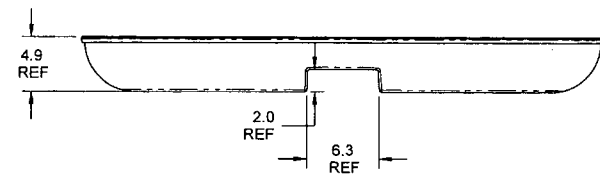
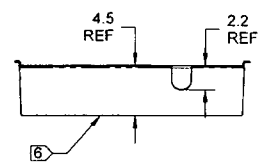
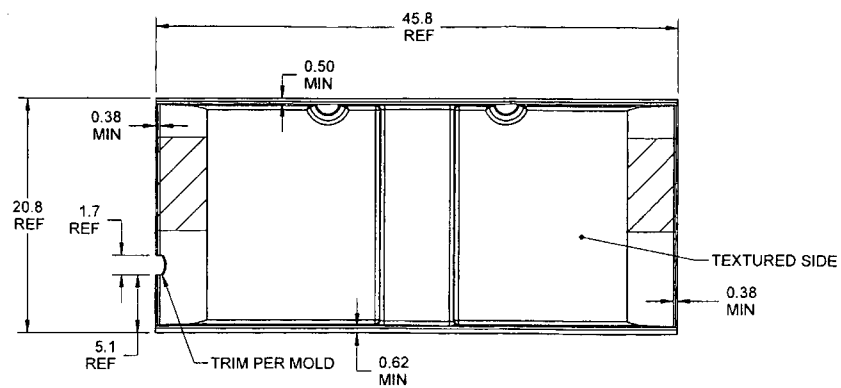
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

83083



RELEASED

D3940-1 FLOOR PROTECTOR (407)

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SE	DRAWING NO. D3940	REV. A
MFG. APPR.	SE	SHEET 2 OF 2	
APPROVED	SE	TITLE FLOOR PROTECTOR (407)	SCALE NTS
DE APPR.	SE	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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